

Date: Tuesday, 23/12/2008 1:22:30 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP SPACER
Job Number :	44293C		
Estimate Number :	10356		
P.O. Number :		Part Number :	D2279
This Issue :	23/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2279 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :	40087C	Drawing Revision :	D
	Type :	Material :	
	SMALL /MED FAB	Due Date :	05/01/2009
Written By :		Qty:	16
Checked & Approved By :		Um:	Each
Comment :	Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1544 sf(s)/Unit Total : 2.4696 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2279
 Batch: 107572 B 8-12-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D 2279
 Dwg Rev: D
 Prog Rev: D

B 8-12-30

(18)

2-Deburr if necessary

B 8-12-30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

06-12-30 (18)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form As per Dwg D2279

EP 09/01/13 - SB 09/01/19 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 1:22:30 PM
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Drawing Name: STEP SPACER

Job Number: 44293C

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/20 (H8)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 09-01-20 (X18)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HL 09/01/20 (18)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Sylvie.

SS 09/01/21 (X8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



MF 09-01-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

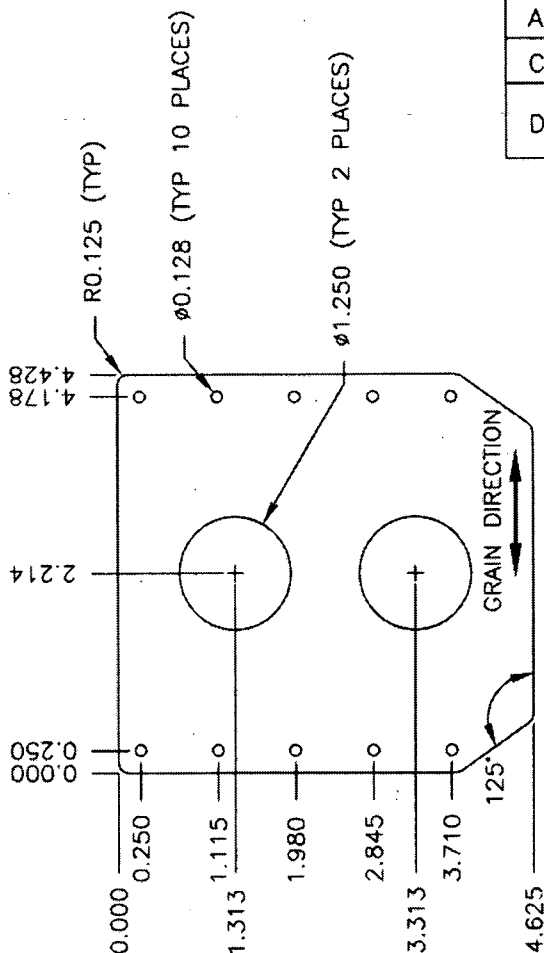
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RE		APPROVED [Signature]		DRAWING NO. D2279	REV. D SHEET 1 OF 1
DATE 98.10.05		TITLE STEP SPACER		SCALE 1:2	
A	94.10.13	NEW ISSUE			
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881			
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912			



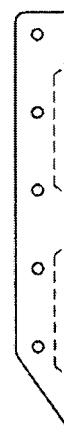
FLAT LAYOUT

RELEASED
98.10.08 DS

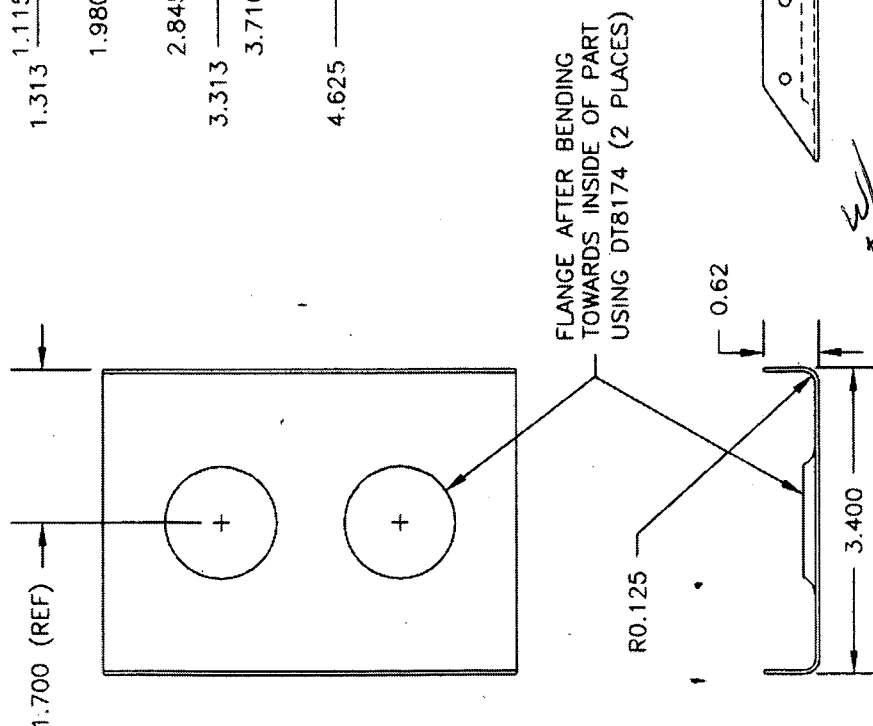
~~UNDER REVIEW~~

~~01.03.15 CP~~
~~DESIGN OK, BUT CHECK WITH~~
~~JB BEFORE MANUFACTURE~~

OK 4/19/80



W/O 293C



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng.	Sign & Date			

NOTE: Date & initial all entries